

De rev 54999

# Work Order ID 46180B



Page 1

October 23, 2009 2:21:35 PM

Item ID:	D3186-4	Accept		Setup	Start	
Revision ID:	D					
Item Name:	Spacepod Door, RH				Stop	
Start Date:	7/15/09	Start Qty:	1.00			
Required Date:	8/03/09	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3186	Rev D/E								

100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)								

ET 09-12-29

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

09-12-30

120	Identify as per dwg & Stock Location: W/O 53185	0.00							
Packaging	Memo	0.00							
Packaging									

09-12-30



# Work Order ID 46180B

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Item ID: D3186-4

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, RH

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/09  
mf  
10-01-05

10  
11  
12  
13  
14

# Picklist Print

October 23, 2009 2:23:16 PM

Page 1

Work Order ID: 46180B

Parent Item: D3186-4RevD

Parent Item Name: Spacepod Door, RH



Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

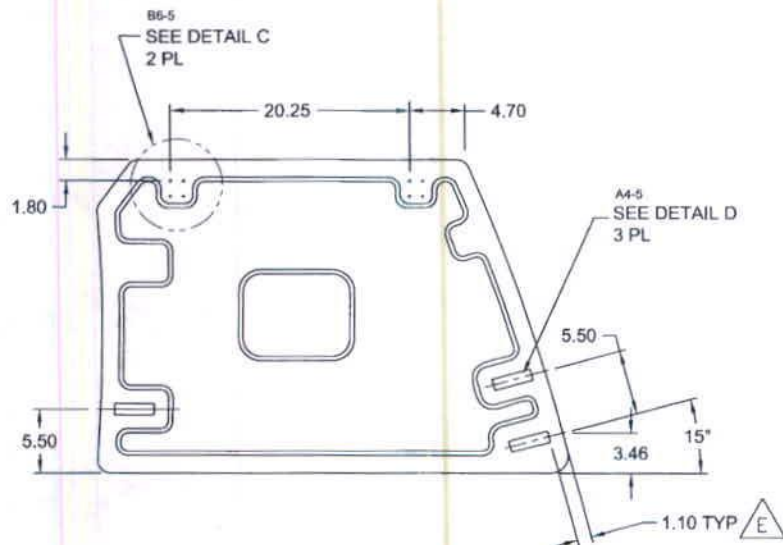
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-2MRevD  SPACEPOD DOOR RH		Manufactured	No			100	Each	0.0000	0.0000 		RT 10-01-09	

53191





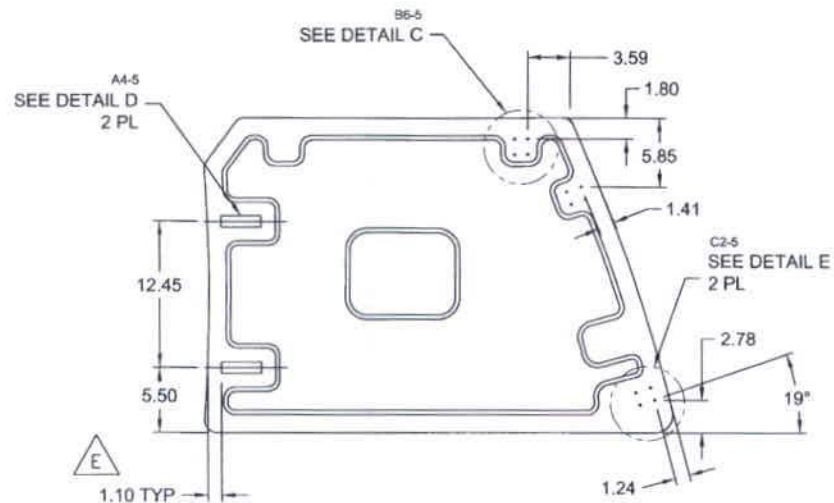
W046180B



**D3186-1 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



**D3186-3 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

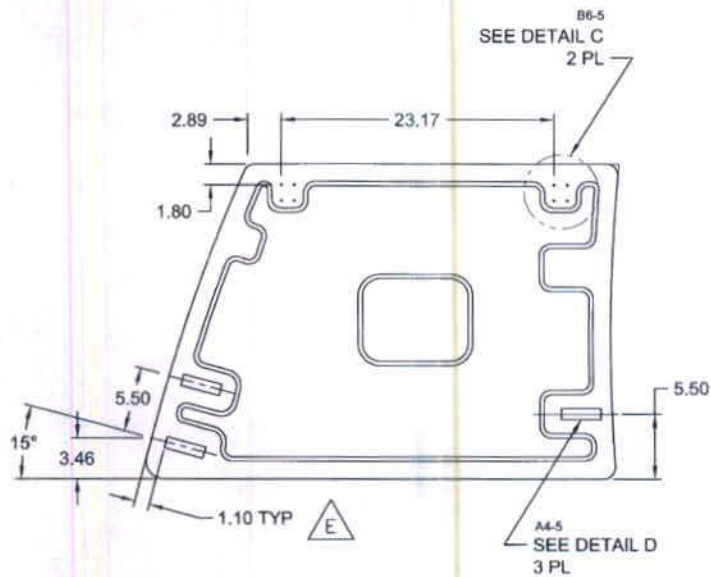
**RELEASED**  
2009-09-09

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/2M/3/4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	IP		
MFG. APPR.	AD		
APPROVED	AD		
DE APPR.	AD	<b>SPACEPOD DOOR</b>	
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED BY THE FORMED CONTRACTOR PART 17 AS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

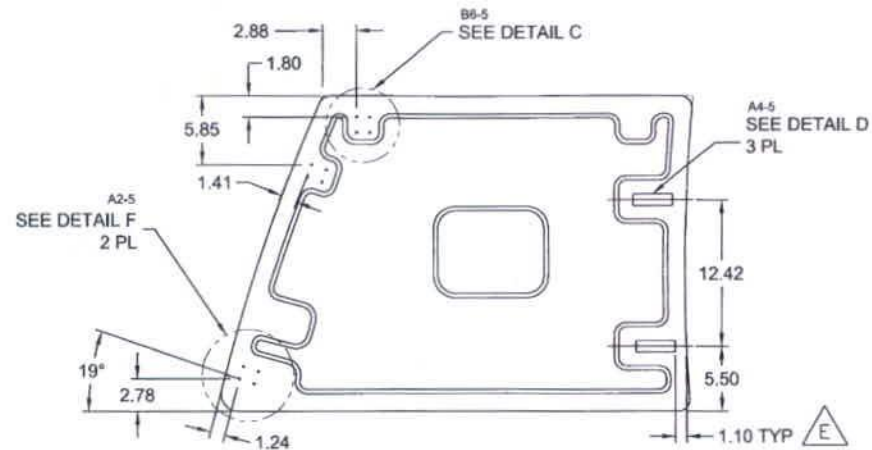




W/O 46180 B



**D3186-2 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M



**D3186-4 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M

**RELEASED**  
2009-09-09

**NOTES:**

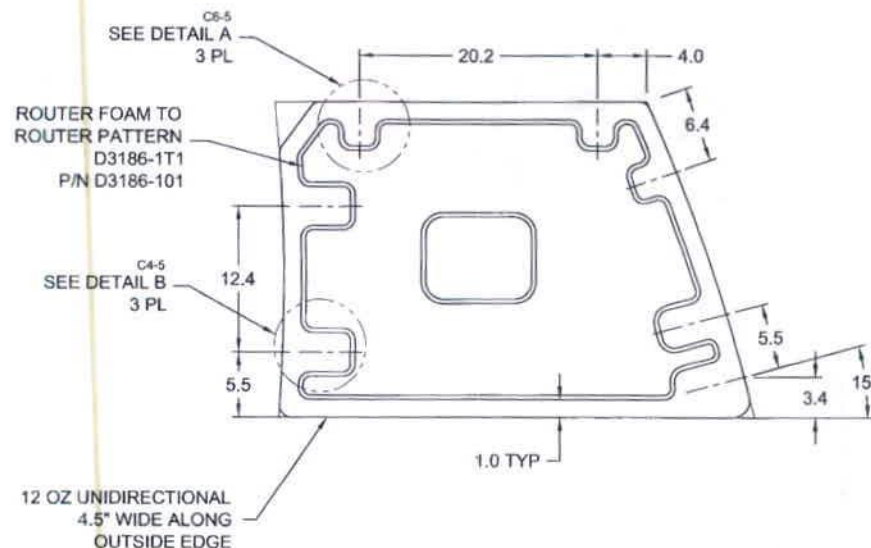
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	U	DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 2 OF 5
APPROVED	MM	TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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W/O 46180B

MAIN LAYUP  
9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY



**D3186-1M SPACEPOD DOOR AS MOLDED**

**NOTES:**

**1) MATERIAL:**

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
LAMINATE PER DART QSI 006 4.0  
LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8005 FOR DOOR LAYUP

**RELEASED**  
2009-09-08

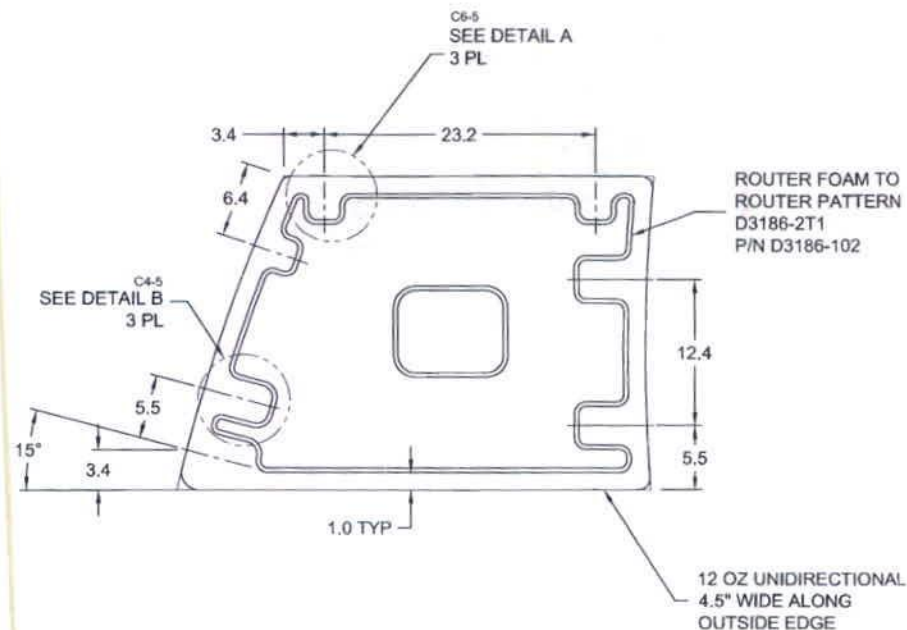
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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W/O 46180B

# MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY



## NOTES:

### 1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
LAMINATE PER DART QSI 006 4.0  
LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

## D3186-2M SPACEPOD DOOR AS MOLDED

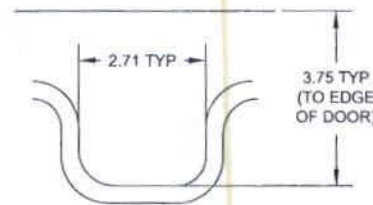
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2009-09-09  
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MFG. APPR.	RF	D3186	SHEET 4 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD DOOR	NTS
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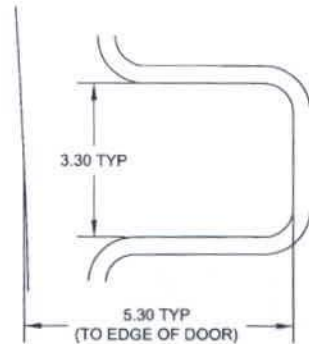




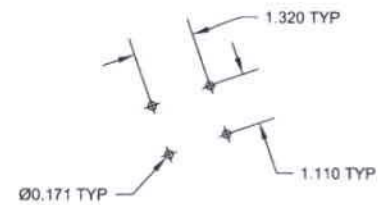
W/O 461803



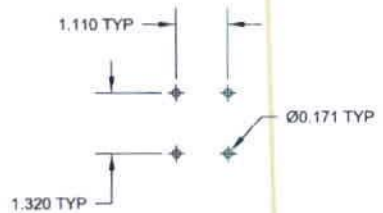
**DETAIL A** D6-3  
SCALE 4X D4-4



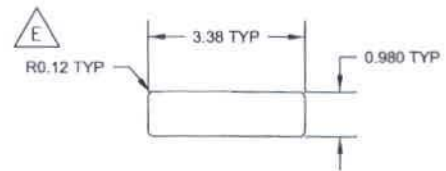
**DETAIL B** C6-3  
SCALE 4X C6-4



**DETAIL E** C1-1  
SCALE 4X

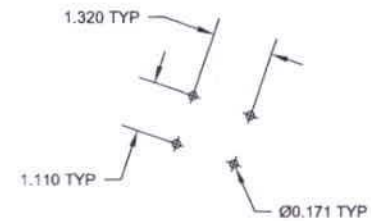


**DETAIL C** D7-1  
SCALE 4X D3-1  
D6-2  
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D** C5-1  
SCALE 4X D4-1  
B6-2  
C2-2



**DETAIL F** C4-2  
SCALE 4X

**RELEASED**  
2009-09-09

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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3186	REV. E SHEET 5 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE SPACEPOD DOOR	SCALE NTS
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DELASTEK COMPOSITES INC.  
2699, 5<sup>ème</sup> Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice #	13196
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Laçelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
09/07/2009	07/07/2009	6013	Chantal Lavoie		PO10038		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC-SAV-AERONAUTIQUE	REWORK D31882P Spacepod Body RH Rework spacepod body RH 9 hours @ 60 \$/hour = 540 \$ Material cost= 135 \$			

8/9/10

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

Accepted by:

  
Quality department



AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

